

## **ABSTRACT OF THE DISCLOSURE**

A spot drilling tool includes a drill holder and an insert removably mounted to the holder. The insert is a standardized part configured to support a drill point in a predetermined position forward of the drill holder and centered on the rotational axis of the drill holder. The drill point has two flutes and two substantially conical land surfaces extending between the flutes. The land surfaces have centers of curvature offset from the rotational axis of the insert to provide radial clearance for the trailing portion of the land. A chisel edge at the tip of the drill point is supported by a tapered web defined between the diagonally opposed and offset flutes. Linear cutting edges are formed at the junction of a planar flute surface and the conical land surface. The cutting edges define a narrow included point angle of between 50° and 80°.

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